

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027925**Date Inspected:** 06-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Andrew Keech**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI met with Quality Control Inspector (QCI) Andrew Keech. The QAI and the QCI were informed that several indications reported from surveying ESW weld S (S-041). The QAI and QCI reviewed the areas and noted that one of the indications was transposed with the incorrect Y location. The QAI and the QCI determined the Y location to be 7540mm. The QAI and the QCI witnessed the excavation of the indication. At 2mm depth intervals the excavated weld was visually examined and magnetic particle testing (MT) was performed by the QCI. The QAI noted that at 16mm deep, there was a 5mm transverse indication observed with MT. The QAI Robert Mertz, the Structural Materials Representative (SMR) Aaron Prchlik and the contractor's Welding Quality Control Manager (WQCM) Jim Bowers were present and observed the indication. See the attached photos. Additional grinding was performed and the area was re-examined with MT. There was no indication visible at an excavation depth of 18mm. The QAI was informed that additional areas will be excavated. This work was in progress at the end of the shift.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

The QAI relayed the status of the UT inspection / excavation to the QAI Lead Bill Levell and Danny Reyes. There were other conversations between the QAI and ABF personnel regarding the weld excavation. The QAI and the QCI Andrew Keech had conversations regarding the ESW scanning and excavation inspection. The QAI did not monitor any welding or repairs during this shift. Except as described above, there were no other notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
